

65 0 JFL 2015-11-1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

Work Order ID 138215

Tuesday, October 27, 2015 11:05:53 AM

138215

Page 2

Item ID: D3873-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bushing

Stop

NS2

Start Date: 10/21/2015 Start Qty: 50.00

50

Cust Item ID:

Required Date: 10/26/2015 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.02

Quality Control

DAS

44

9-89

15/11/12

130

Identify as per dwg & Stock Location: FP001

0.00

130

Packaging

Memo

0.01

Packaging

LOCATION : FP001

65 MJS 15-11-12

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.08

Quality Control

NOV 12 2015

MJS NOV 12 2015

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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

Tuesday, October 27, 2015 11:05:53 AM

Page 1

Work Order ID: 138215

138215

Parent Item: D3873-1

D3873-1

Parent Item Name: Bushing

Start Date: 10/21/2015

Required Date: 10/26/2015

Start Qty: 50.00

Required Qty: 50.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.625		Purchased	No			100	f	22.8270	0.06	3.157895			

M303R0 625

303 Round Bar 0.625"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	12	
m133368	12	
MAT028	10.827	
119009	0.583	
124081	3.369	
m131999	0.875	
m133053	6	

4.000 ^{pk} JFC 2015-11-11

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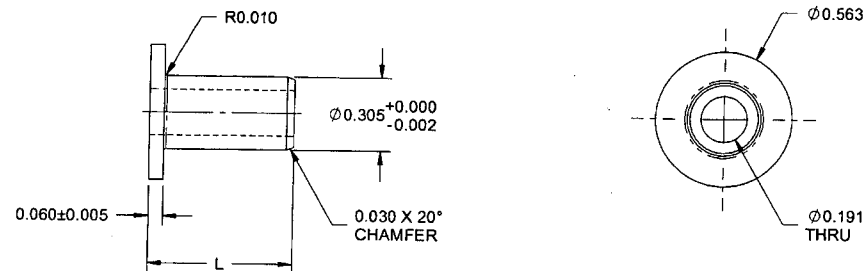
Root Cause				FAULT CATEGORY							
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Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
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Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
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LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

FIRST ARTICLE INSPECTION CHECKLIST

~~DAS~~

44

9-89



D3873-X BUSHING

DART P/N	L	WEIGHT (lbs)
D3873-1	0.600	0.010
D3873-3	0.120	0.005
D3873-5	0.270	0.007



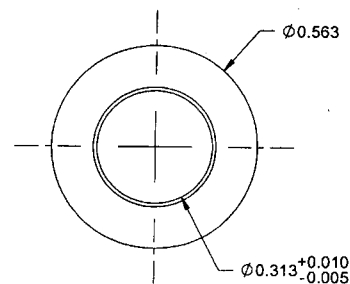
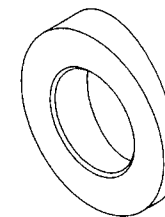
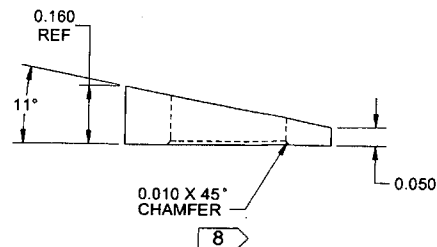
NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 138215 MW
1540-27

RELEASED
2011-09-12
JWP

C	ADD D3873-3/-5/-7 (ZN B6-1 & B5-2)	RF	11.06.14
B	$\phi 0.563$ WAS $\phi 0.63$ (C3-1, TO FIT TRIBAG GIRT)	CP	10.07.22
A	NEW ISSUE	MB	09.01.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	GP	DRAWING NO.	REV. C
MFG. APPR.	E	D3873	SHEET 1 OF 2
APPROVED	12	TITLE	SCALE
DE APPR.	12	BUSHING	NTS
DATE	11.06.14	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



C **D3873-7 SPACER**

RELEASED
2011-09-12
AP

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.005 lbs
- 8) IT IS ACCEPTABLE TO BE DEBURR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3873	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BUSHING	NTS
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